Work Order ID 73825

Friday, September 16, 2011 11:31:04 AM

Item ID: D2646 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Aft Cap

Start Date: 9/16/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Approvals: **Process Plan:** V **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2646	Rev C								
100	PURCHASING	0.00							
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: 14911 ☐1-Spin as per Dwg D2646 ☐2-Material release note required					11-09-16 200			
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	**Memo**	0.00							
Packaging	Ensure Material Release Note is attached					10/6/21 300			
120	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control						county 4200 Asplos			

5 11/02/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73825

Friday, September 16, 2011 11:31:04 AM

Item ID: D2646 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Aft Cap

Start Date: 9/16/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Small Fab	Small Fab					RB 11-10-14	(200)		
Small Fab	**Memo**	0.00							
	1-Drill using DT8026 as per Dwg D2646.□2-Open holes to .297 as per Dwg D2646.□3-Deburr								
140	QC5- Inspect part completeness to step on W/O	0.00				counts			
QC	**Memo**	0.00 S 11-10-14				+200			
Quality Control						DS/0.19			
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00				200 counted	0		11/10/12
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73825

Friday, September 16, 2011 11:31:04 AM

Item ID: D2646 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Aft Cap

Start Date: 9/16/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 3:30 ☐OVEN TEMPERATURE: 320°F ☐FINISH TIME: 4:00								
170	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
180		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	Install inserts as per Dwg D2646								

200 x ø Mf 11/15/24

M 117745

200 ø Mf 11/15/24 counted

200 ø Mf 11/15/24 counted

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 73825

Friday, September 16, 2011 11:31:04 AM

Item ID: D2646 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Aft Cap

Start Date: 9/16/2011 **Start Qty:** 200.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 200.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00				200	0		11-11-03
QC	**Memo**	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: FP-1	0.00				200 counted	0		11/11/03
Packaging	**Memo**	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							11/13
QC	**Memo**	0.00							
Quality Control									MF 11-11-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 11:31:01 AM

Work Order ID: 73825

Parent Item: D2646

Parent Item Name: Aft Cap

Start Date: 9/16/2011 **Required Date:** 10/14/2011

Start Qty: 200.00 **Required Qty:** 200.00

Comments: IPP: G□05.08.22□Hole size revised in Step 5□KJ/JLM□
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			110	Each	1,117.000	2	400			
Insert													
ALS-4-1032-130					M118386								
				Location			**Loc Qty**		**Loc Code**				
				ST282			1117						
					117717		899						
					118386		218			400			
D2646P		Purchased	No			180	Each	0.0000	1	200			
Aft Cap													

M 4/12/12

Pull 9/21 (200)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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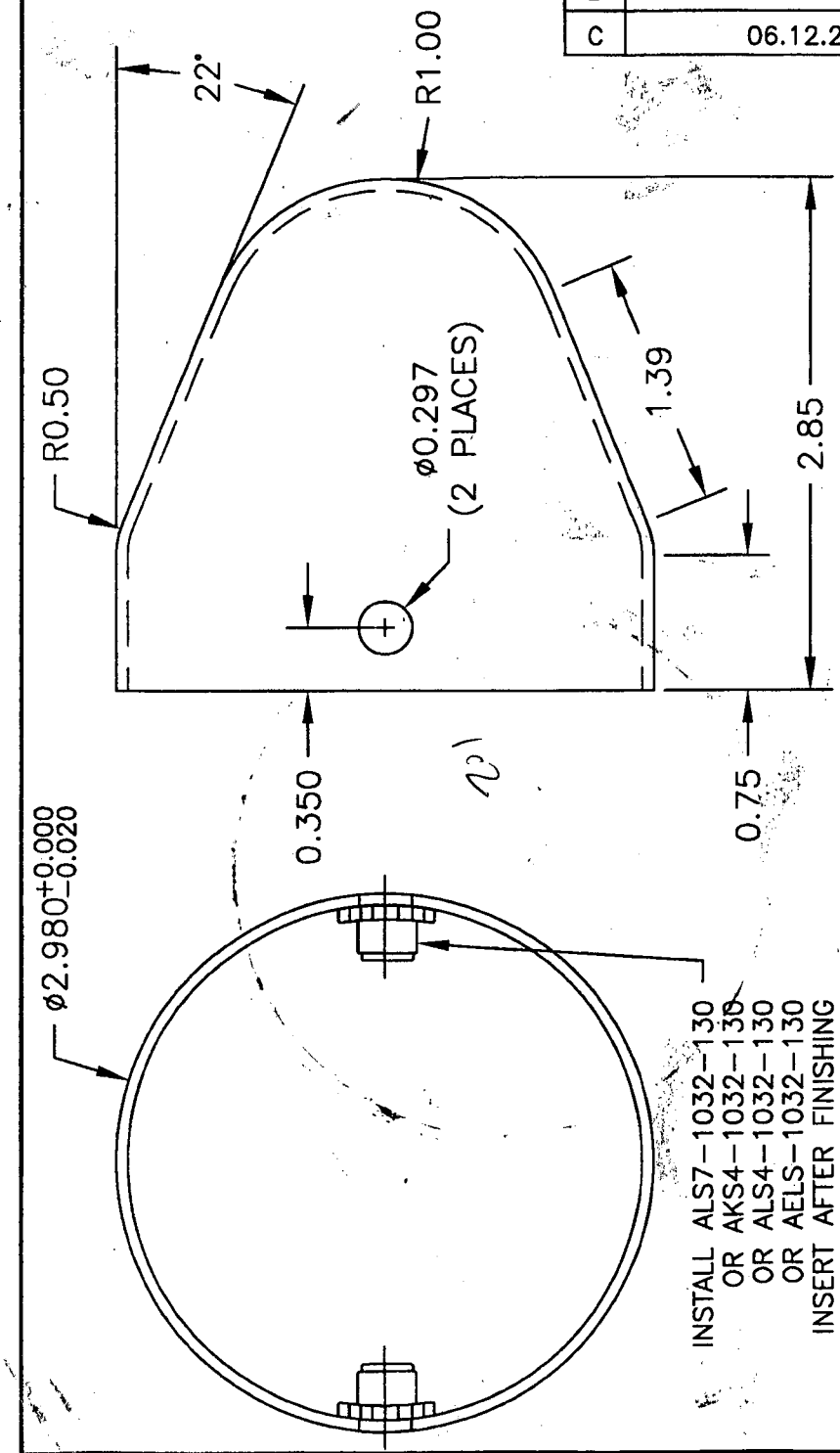
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
DS	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. / REV.
		D2646 / C
DATE	TITLE	SHEET 1 OF 1 / SCALE
06.12.20	AFT CAP	1:1

A	97.03.25	NEW ISSUE
B	05.04.01	CHANGE TO CLOSED INSERTS
C	06.12.20	CHANGE TO OPEN ENDED INSERTS

RELEASED
07.02.12



D2646 AFT CAP

1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14911

Purchase Order Date 9/16/2011
PO Print Date 9/16/2011

rder From : VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

Contact Name		**Buyer**	Brigitte Golden
Vendor Phone	604 530 7455	**Requisition Nbr**	
Vendor Fax	604 530 7490	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

hip To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

ne Nbr	**Reference** **Revision ID** **Vendor Part Number**	**Description/** **Mfg ID**	**Req Date/** **Taxable**	**Req. Qty/** **Unit of Measure**	**Ship Method**	**Unit Price**	**Extended Price**
	D2646P	Aft Cap	9/20/2011 Yes	200.00 Each	FedEx Overnight	$6.4700	$1,294.00

Special Inst: As per DWG: D2646, Rev: C
B73825

PO Total: **$1,294.00**

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1 **Change Date:** 9/16/2011

Sieg's Manufacturing Ltd. Packing Slip

Metal Spinning & Metal Fabricating
6236 205 Street
Langley, BC, Canada V2Y 1N7
Phone:(604)530 7455 Fax:(604)530-7490
Check out our website: www.siegsmfg.com

Packing Slip No.:	39756
Date:	09/20/2011
Page:	1

Sold to:	Ship to:
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 14911	**Sold By:** KAULBARS, ARLA
Shipped By:	**Ship Date:** 09/20/2011
Tracking No.:	

Item No.	Unit	Description	Quantity
D2646P	Each	Aft Cap	200

Comment:

Sieg's Manufacturing Ltd.
6236 205 Street Langley, B.C. Canada V2Y 1N7
Ph#: (604)530-7455 fax#: (604)530-7490
arla@siegsmfg.com

INSPECTION REPORT

Date: Sept 20/11
Customer: Dart Aerospace
Packing Slip: 39756

Part#:	Quantity	Material	Check holes	Insp. By.
D2646P	200	063 1100-0	N/A	[illegible]

Notes:

Material Certification Attached: ✓

ALCOA

Alumax Mill Products, Inc.
(an Alcoa Inc. business)
1480 Manheim Pike
Lancaster, Pa. 17601

Certification of Test Results

SOLD TO
COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO
LEVELTEK
3236 STATE ROAD 39
PO BOX 148
LA PORTE , IN 46352

CERT NO 0001260979
DATE 12/13/2010
SKID NO 957160
SKID WGT 6,439
PAGE 1 **OF** 1

ORDER NO	LO0400	**PO NO**	5400080193-R01		
ITEM NO	1	**PART NO**	ALFLR01226		
ALLOY	1100	**TEMPER**	O	**FORM**	COIL
GAUGE	.06300	**WIDTH**	48.0000	**LENGTH**	0.0000

MILL FINISH
NON ANODIZE QUALITY
OUT: STANDARD MILL FINISH
IN: STANDARD MILL FINISH
NOT EMBOSSED

Alcoa Certification 0001260979

LOT: 461649 COIL: B01 DROP: 0P06534

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
0P06534	0.12	0.43	0.13	0.05	0.05	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 14.6 KSI
TAIL ULTIMATE STRENGTH 15.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 6.8 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.0 KSI
HEAD ELG IN 2 IN., AT FRACTURE 30 %
TAIL ELG IN 2 IN., AT FRACTURE 30 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-07
CHEMISTRY EXPRESSED AS % W/W FOR EACH REPORTED ELEMENT
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-10

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, ASTM B209-07 1100 O

** END OF CERTIFICATION **

THIS IS A NON-STRUCTURAL PART. ASTM B209-07 IS ACCEPTABLE ON THE BASIS OF SIMILARITY WITH OTHER DART "M" ALLOY DWG'S. JL 09.22

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full. This material was melted in the United States or a qualifying country (REF DFARS 225.872.1A); It was manufactured in the United States.

These commodities, technology and software exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to U.S. law prohibited. This certification complies with EN 10204:2004.

Authorized By:
JEFF KREADY, LAB SUPERVISOR